

**Work Order ID 69419**

Tuesday, May 10, 2011 3:31:35 PM



Page 1

Item ID: D3436-044

Accept



Setup Start



Revision ID:

Item Name: Step RH

Stop



Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 110510 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr.	Revision Nbr
D3436	Rev A

100

0.00



Large Fab

Large Fab

0.00

Memo Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and

Dwg D3436 Dwg Rev: AQty  Part Number  Description  BatchA/R  N/A  4130 Welding Rod  M19317

*11/10/06 2 8*

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436 Dwg Rev:

Qty  Part Number  Description  Batch  
A/R  N/A  4130 Welding Rod  M19317Weld cap D3436-7 as per Dwg D3436 Dwg Rev: AQty  Part Number  Description  Batch  
A/R  N/A  4130 Welding Rod  M19317

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



BAND SAW

0.00

Bandsaw

Jeaspa Bandsaw

Memo

0.00

1-Slit part D3436-041 on bandsaw as per Dwg D3436  
2- deburr

211.09.06

2 0

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2 0 BE1109106

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 u109106

(2)

R14

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

140



Powdercoat

Powder Coating

150



QC

Quality Control

155



Small Fab

Small Fab

Operation  
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

11:45 0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*Apply black anti-slip paint as per Dwg D3436 and QSI 005 4.4\*\*\*

wingwalk; M118313

2x S M 11/09/06  
RH

QC3- Inspect Part Finish

0.00

Memo

0.00

2xR R d M 11/09/06

Small Fab

Memo

0.00

Small Fab

Memo

0.00

Bond pads per dwg and QSI 015

J. B. 1/09/07 (2)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC5- Inspect part completeness to step on W/O

0.00

84105157

0.00

(+2)

R4

QC

Quality Control

170



Identify as per dwg &amp; Stock Location:

0.00

11917 SL (2)

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

0.00

11917 SL (2)

WMS

11-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Tuesday, May 10, 2011 3:31:46 PM

Page 1

Work Order ID: 69419



Parent Item: D3436-044



Parent Item Name: Step RH

Start Date: 5/10/2011

Required Date: 5/30/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A□ 05.05.11□New Issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3436-5  
 Manufactured No 100 Each 28.0000 4 8 5/11.09.02

Bushing  
 ST 20 46592 20 WA020 8 64065 8 4+4 2 5/11.09.02

D3436-7  
 Manufactured No 100 Each 46.0000 1 4+4 2 5/11.09.02

Cap  
 WA021 46 56836 46 2 2 5/11.09.02

D3436-9  
 Manufactured No 100 Each 6.0000 2 4 5/11.09.02

Pad  
 GA 2 56830 2 ST053 4 66567 4 40 369599 40 5/11.09.02

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, May 10, 2011 3:31:46 PM

Page 2

Work Order ID: 69419



Parent Item: D3436-044



Parent Item Name: Step RH

Start Date: 5/10/2011

Required Date: 5/30/2011

Start Qty: 2.00

Required Qty: 2.00

D3436-4



Right Step

Manufactured No

100

Each

2.0000

1

2



5/11.08.02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA021

2

51786

2

D3436-1



Clamp

Manufactured No

155

Each

44.0000

1



2

5/18.09.02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA021

44

17679

44

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:4	
A	05.04.28	NEW ISSUE	

SHOP COPY

RETURN TO

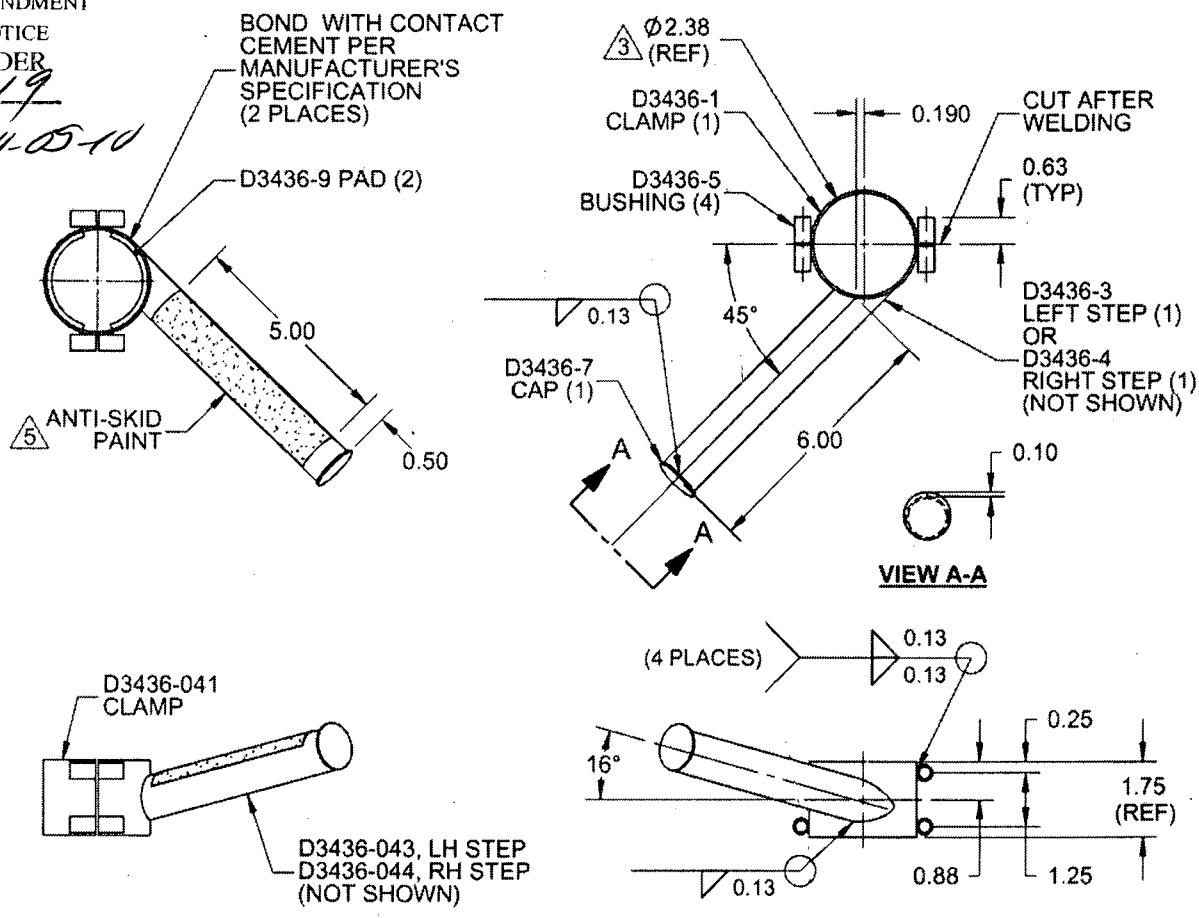
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. *094119*

*011-05-10*



### WELDING

RELEASED

*05.05.27* *✓*

### NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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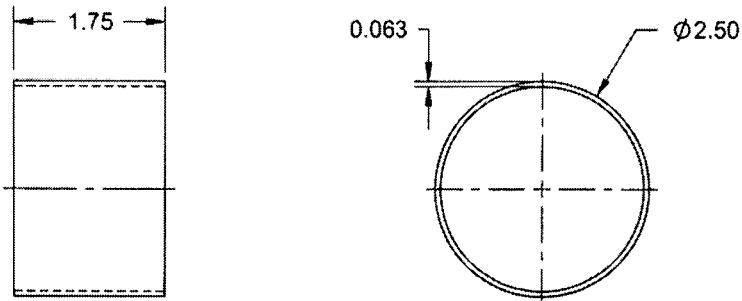
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NOTE: Date & initial all entries

**DART**

DESIGN MB	DRAWN BY MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:2	

*u/o 6/04/09***D3436-1 CLAMP**

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)

**D3436-5 BUSHING**

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

**RELEASED***05-05-27***D3436-1/ -5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

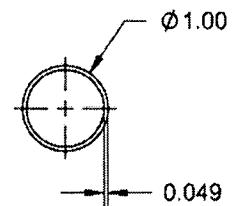
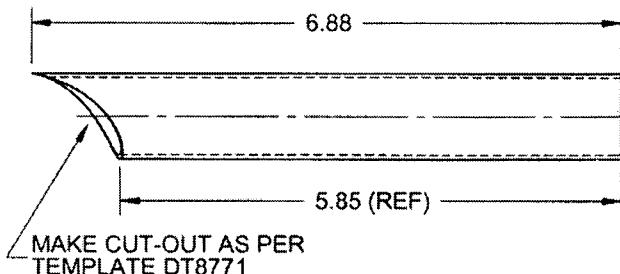
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NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:2	

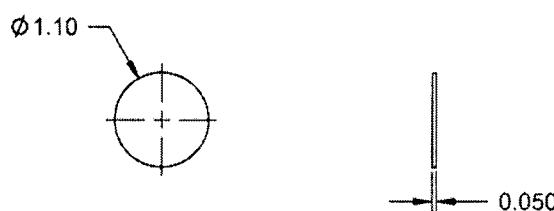
*u/l 69419*



### D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



### D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

*05-05-27 MM*

### D3436-3/ -7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

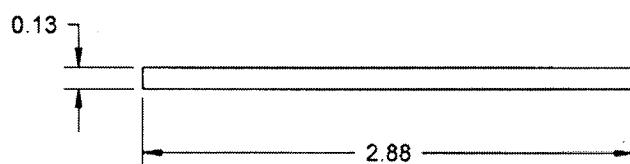
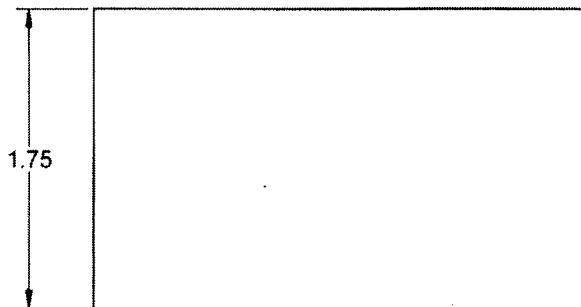
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CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:1	

u/b 69419



RELEASED  
05.05.27 *MM*

### D3436-9 PAD

#### NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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